

Wednesday, 5/16/2007 1:40:46 PM
Kim Johnston

Process Sheet

23

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT WEB
Job Number : 32405
Estimate Number : 10791
P.O. Number : N/A
This Issue : 5/16/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 31930
Written By :
Checked & Approved By :
Comment : Est Rev.B 05.09.23 Procedure change KJ/JLM

Part Number : D3282041
Drawing Number : D3282 REV C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 6/3/2007 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2792130 EXTRUSION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2792-130 Extrusion B24030

Identify as D3282-1

7-5-23

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

7-5-23

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

SA 070529

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 070529

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 070529

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Insp

Part No: D3282-041 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-06-06	3.0	1 web was found to be twisted when it was installed in the HAAS. R.C. came in from the supplier, or was twisted during shipment.	<i>[Signature]</i> 07/06/06	Web is scrap do not , use for Tooling. I.D. web as "Tooling use only".	<i>[Signature]</i> 07-06-29	<i>[Signature]</i> 07-06-06	<i>[Signature]</i> 07/06/06	<i>[Signature]</i> 07-06-06

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:40:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 32405

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

R 7-6-6

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 7-6-6

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

B 31942

R 7-6-6

9.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total : 570.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

M100854

R 7-6-6

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3 *M103674*

R 7-6-6

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-6-6

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *4/6*

R 7-6-6 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:40:46 PM

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 32405

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



⑨

Comment: FINAL INSPECTION/W/O RELEASE

12/27/07

Job Completion



U. J. 07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32405
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

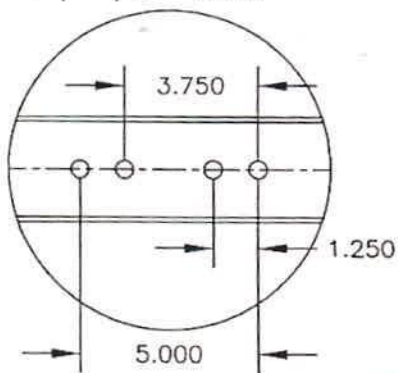
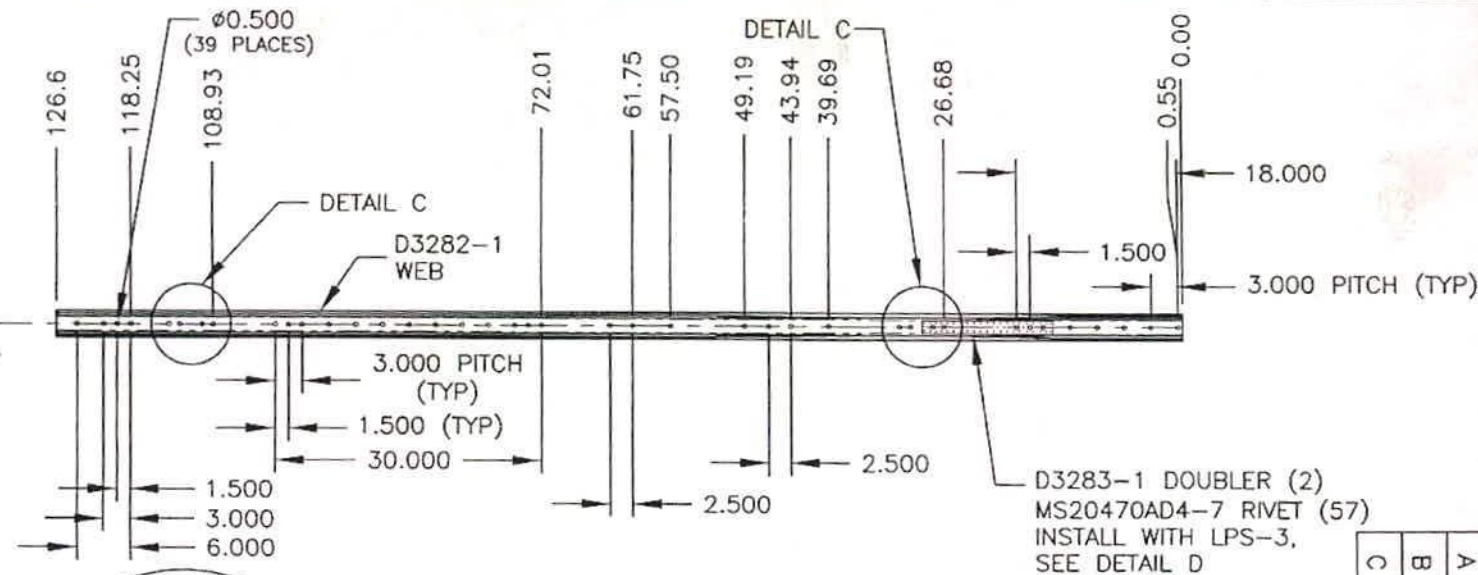
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.6				
1.500	+/-0.010	1.500				
3.000	+/-0.010	3.000				
6.000	+/-0.010	6.000				
1.250	+/-0.010	1.250				
30.000	+/-0.010	30.000				
1.500	+/-0.010	1.500				
72.01	+/-0.030	72.01				
61.75	+/-0.030	61.75				
57.50	+/-0.030	57.5				
49.19	+/-0.030	49.19				
43.94	+/-0.030	43.94				
39.69	+/-0.030	39.69				
26.68	+/-0.030	26.68				
0.55	+/-0.030	.55				
1.970	+/-0.010	1.970				
2.38	+/-0.030	2.38				
0.05	+/-0.030	.05				

Measured by: <u>SG</u>	Audited by: <u>JL</u>	Prototype Approval:	N/A
Date: <u>07.05.27</u>	Date: <u>07/05/27</u>	Date:	N/A

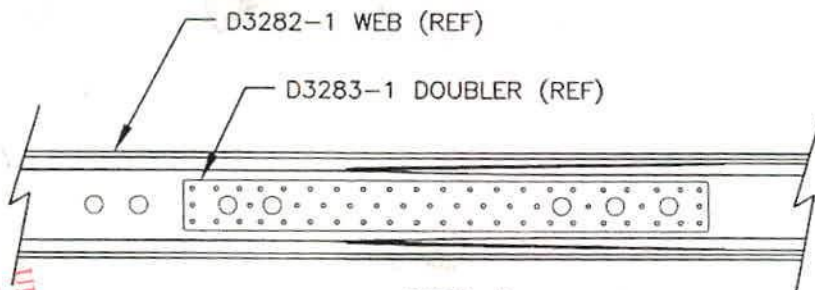
Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. C
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D3282	SHEET 1 OF 2
DATE	05.08.09			TITLE	FLOAT WEB, 206L/407	
A	04.05.05			NEW ISSUE		
B	05.03.16			MOVE HOLES, ADD D3390-1 DOUBLERS		
C	05.08.09			REMOVE D3390-1, NOW MACHINED		
				SCALE	1:20	



DETAIL C
SCALE 1:5
RIVET HOLES NOT SHOWN
FOR CLARITY



DETAIL D
SCALE 1:5

RELEASED
05-09-12 *[Signature]*

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

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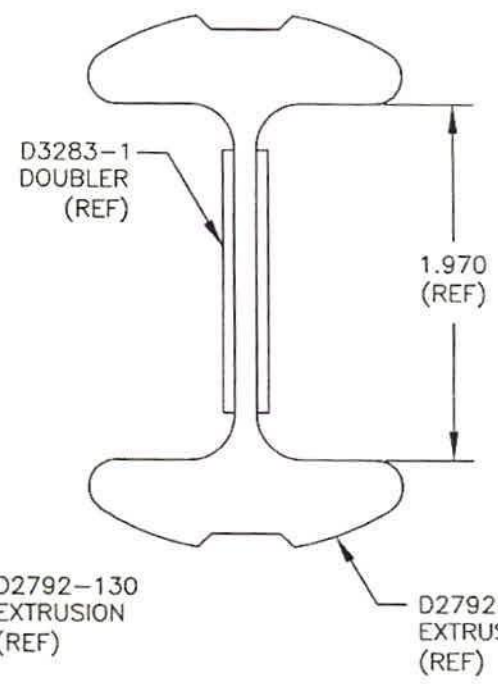
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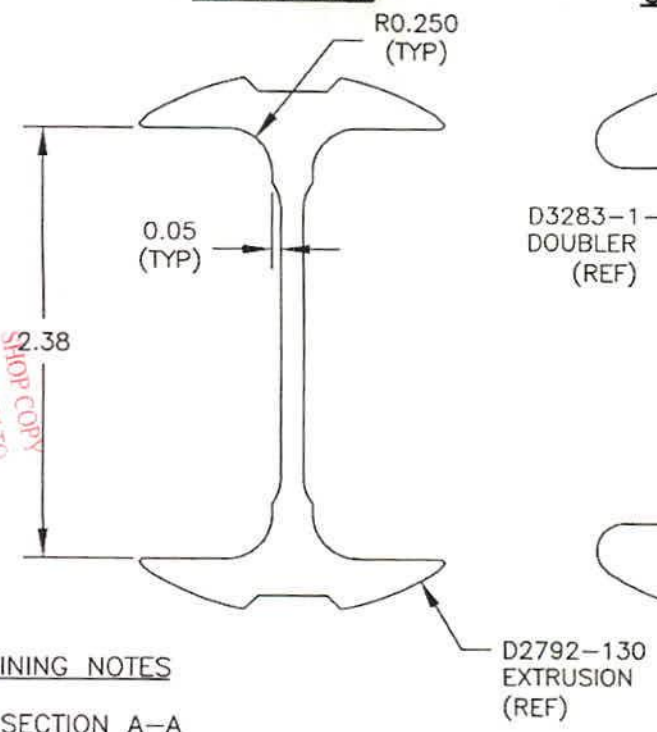
DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	TITLE	D3282	REV. C
				SHEET 2 OF 2
				SCALE
				1:20

SECTION B-B



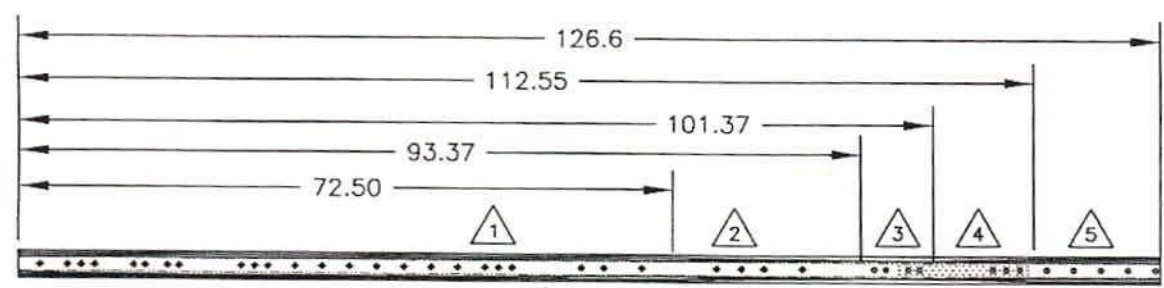
SECTION A-A



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK CENTER
32405

D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
05-09-12